

Date: Friday, 23/01/2009 8:46:18 AM
User: Julie Dawson

Process Sheet

split

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: JACK
Job Number	: 45181		
Estimate Number	: 10527		
P.O. Number	:	Part Number	: D33361
This Issue	: 23/01/2009 S.O. No. :	Drawing Number	: D3336 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 43352	Material	:
Written By	:	Due Date	: 05/02/2009
Checked & Approved By	: <u>JD 29.01.23</u>	Qty:	10 Um: Each
Comment	: Est. A05.01.13 New issue KJ/JLM		
	: Est. A05.12.13 Added paint EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 8044C209/01/23

For D3336-1 Jack P/N: 76508

(10)

Possible Supplier: Auto PartsProduct Specification sheet is required

2.0	76508	JACK
-----	-------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
JACK

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

Ensure Product Specification sheet is attached

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Drill base of jack using DT8761 as per Dwg D3336

see attached drawing from RF

2-Check ram length, then tack weld as per Dwg D3336

09.01.29

3-Drill and Tap ram as per Dwg D3336

N/A CR

C209-05-07

Qty (1) HC-12 1/4"-20UNC x 1" long HEX BOLT, SPAN → B

M16626

(X8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 23/01/2009 8:46:18 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK

Job Number: 45181

Part Number: D33361

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Paint base cuts to match color per dwg D3336

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Red touch up wet paint

09-05-14

(KS)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/05/14

(KS)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

CARL

09/05/14

(KS)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/14

Job Completion



mf 09-05-19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

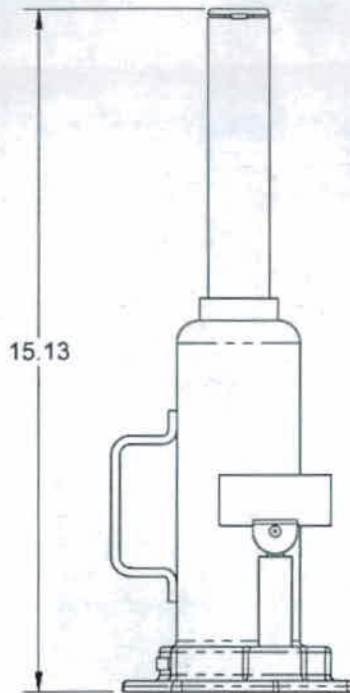
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3336	REV. A SHEET 1 OF 1
DATE 04.12.16	TITLE JACK	SCALE 1:2	
A	04.12.16	NEW ISSUE	



DETAIL A: SIDE VIEW
SCALE 1:4

DRILL 0.312 PER
TEMPLATE DT8761
(2 PLACES)

COUNTER BORE $\varnothing 0.38$
IF NECESSARY FOR
CLEARANCE OF BOLT
HEAD (2 PLACES)

DRILL 0.201 x 1.00 DEEP
AND TAP 1/4-20 x 0.75 DEEP
AT CENTER OF CAP.

WELD CAP WITH SHAFT
WITH 0.375 LONG
TACKS (2 PLACES)
AROUND PERIMETER

RELEASED
[Signature]
05/02/09

TRIM EDGES AS PER
TEMPLATE DT8761
AND PAINT CUTS TO
MATCH COLOR.

D3336-1

NOTES:

- 1) MATERIAL: 8 TONS JACK. POSSIBLE SUPPLIER: AUTOPARTS
MODEL NUMBER 76508
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER
NO. 45181

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TRUCK PARTS • PIÈCES DE CAMION
ENGINE-MARINE • MOTEUR-MARINE
PERFORMANCE PARTS • PIÈCES DE PERFORMANCE
TIRES • PNEUS**



Payment due accounts bear 2% interest per month (24% per annum). If this account is placed with a 3rd party collection, an administrative cost of 25% will be added. All exchanges and refund claims must be accompanied by this invoice. Electrical parts not returnable. All parts returned are subject to 20% handling charge. All merchandise sold on this invoice remains the vendor's property until this invoice is paid in full.
TERMS: Payment due on 10th day of the following month.

Aucun remboursement sans cette facture. Net 30 jours. 2% de frais d'intérêt par mois (24% par année) sur compte en souffrance. 20% de frais de manutention sur toute marchandise retournée. Clause pénale une indemnité de 25% sera chargée sur compte sujet à des procédures légales. Les marchandises mentionnées sur cette facture demeurent la propriété du vendeur tant qu'elles ne seront pas entièrement payées. Pièces électriques non-retournables.
TERMS: Compte payable le 10 du mois suivant.

SIGNATURE _____

GST / TPS
101 35 3386 RT0001

1000 RUE LANDSDOWNE HAWKESBURY, ON K6A 1H7
TEL: (613)632-1191 FAX: (613)632-2350

TVQ
1016330716 TQ0001

A TOUS NOS CLIENTS, NOUS VOUS SOUHAITONS UN JOYEUX NOEL ET UNE MERVEILLEUSE ANNEE
TO ALL OUR CUSTOMERS, WE WISH YOU A MERRY CHRISTMAS AND A WONDERFUL YEAR

113336 (613)632-5200
DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7

EXPEDIER
TO A

113336

*** SAME ***

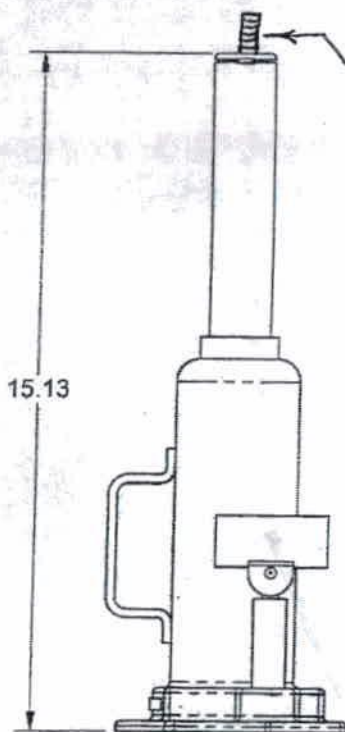
DATE: 1/26/09
13:35
112 MLP

00008044

QTY / COM	SHIP / EXP	CODE	PART No / PIÈCES	DESCRIPTION	LIST EACH / CHACUN	COST / COÛTANT	EXTENSION
8	8	G2S>	NOR76508 ✓	bottle jack		134.00	1072.00
			direct / g2s in163874				0.00
	8	***	SHIP VIA	PIECES / CORE IDT REGULAR	0.00		0.00
<i>Thank You</i> <i>Merci</i>							
INVOICE No / FACTURE	TYPE / SORTIE	TOTAL	DISC / ESC	FRT / TRANS	GST / TPS	PST / TVQ	AMT TO PAY / À PAYER
11923615	INVOICE	1072.00	0.00	0.00	53.60	0.00	1125.60

3014-11
1/4-20 BOLT
DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3336	REV. A SHEET 1 OF 1
DATE 04.12.16		TITLE JACK	SCALE 1:2
A	04.12.16	NEW ISSUE	



DETAIL A: SIDE VIEW
SCALE 1:4

CUT BOLT AND WELD
ON JACK
HC12

1/4-20 BOLT
1"

CPC09-04-29

DRILL 0.201 x 1.00 DEEP
AND TAP 1/4-20 x 0.75 DEEP
AT CENTER OF CAP.

WELD CAP WITH SHAFT
WITH 0.375 LONG
TACKS (2 PLACES)
AROUND PERIMETER

RELEASED
05/02/09

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L Lacelle

From: Roberto Fuentes [rfuentes@dartaero.com]
Sent: January 7, 2009 12:27 PM
To: 'L Lacelle'
Cc: 'Mike Petsche'; 'David Shepherd'; bbeckett@dartaero.com
Subject: RE: Hydraulic grd handling

It is ok with me, if that produce scraps the way it is now, also I check with the guys here at Eagle and said it is fine with them. Only concern with me is make sure the bolt is weld straight with shaft and have good solid weld between cap of the jack and bolt and the thread shown after nut be max. 1/4" and may be add a lock washer. This will required to update assembly drawing.

Roberto

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Wednesday, January 07, 2009 7:44 AM
To: 'Roberto Fuentes'
Cc: 'Mike Petsche'; 'David Shepherd'; bbeckett@dartaero.com
Subject: RE: Hydraulic grd handling

Forgot to include attachment... sorry

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: January 7, 2009 9:42 AM
To: 'Roberto Fuentes'
Cc: 'Mike Petsche'; 'David Shepherd'; 'bbeckett@dartaero.com'
Subject: Hydraulic grd handling

Hi all,
Carl had a grwat idea, to save time and parts, please see attached.
We sometimes break the cap part of the jack, by cutting off the head of the bolt and welding it on, it would take less time and make less scrap...
Let me know what you's think.

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd